clamping the strap *B,* the work is held tight without springing it; and by tightening the nut *C* the clamp is held in place by the bunter and the work is securely supported. When reloading the fixture, the clamp is brought out of the way by means of the handle *D.*

In Fig. 71 is shown a small clamping device used when drilling the rivet holes through the beading *A* and the plate *B.* The steel bracket *C* is fastened by screws to the side of the fixture. The front face of the clamp bracket is used as a stop for the plate

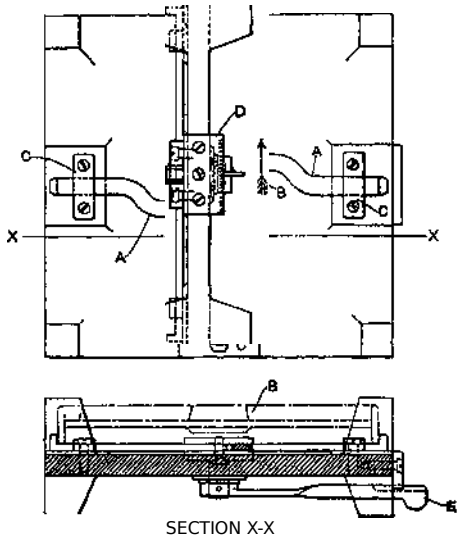

Fig. 69. Clamping Device for Holding Large Work

and the beading, and the clamp *D* with a small hole drilled in one end is fitted loosely in the milled slot in the bracket. The set-screw is located a little higher than the hole in the clamp and by a few turns of the screw the clamp is brought down against the work and forces the beading up against the stop ready to be drilled.

Spring bunters are often used in designing fixtures where

adjustable supports are necessary, and the form of bunter shown in Fig. 72 has proved very efficient. The bunter *A* and the binder *B* fit freely in the holes in the casting. The bunter is